

Date: Wednesday, 28/01/2009 5:02:34 PM  
 User: Julie Dawson

## Process Sheet

|                       |   |                  |                                 |
|-----------------------|---|------------------|---------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services         | Drawing Name     | : "T" HANDLE ASSEMBLY           |
| Job Number            | : 45347A                                      |                  |                                 |
| Estimate Number       | : 11179                                       |                  |                                 |
| P.O. Number           | :   | Part Number      | : D2282041                      |
| This Issue            | : 28/01/2009 S.O. No. :                       | Drawing Number   | : D2282 REV E                   |
| Prsht Rev.            | : NC  | Project Number   | : N/A                           |
| First Issue           | : / / Type : SMALL /MED FAB                   | Drawing Revision | : E                             |
| Previous Run          | : 44403A                                      | Material         | :                               |
| Written By            | :   | Due Date         | : 28/02/2009                    |
| Checked & Approved By | : <u>JW 09.01.29</u>                          | Qty:             | <del>88</del> 98x. 100 Um: Each |
| Comment               | : Est Rev:A Removed from 9 Digit 05-12-02 JLM |                  |                                 |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |        |      |
|-----|--------|------|
| 1.0 | D22823 | Tube |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2282-3

Handle tube

B44443 = 22x7 = 8x  
B45384 = 60x = 70x  
B46428 = 12x

SP. 09. 03. 25

|     |        |      |
|-----|--------|------|
| 2.0 | D22825 | Tube |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2282-5

Handle tube

B44080 = 60x  
B44338 = 8x  
B44320 = 30x

SP 09.03.25

|     |             |                              |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.as per dwg D2282

\*\*\*\*\*brush weld right after welding, to take color off \*\*\*\*\*

A/R ER316L SS

Filling Rod M106115Dwg Rev: E

SP 09.04.06

(98x)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 28/01/2009 5:02:35 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 45347A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC9 ,

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Plc 09.04.07*

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

*B 94-22*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 09/04/22*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *B-A*

*SB 09/04/22*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/23*

Job Completion



*09.04.23*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

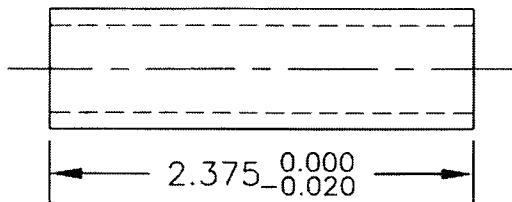
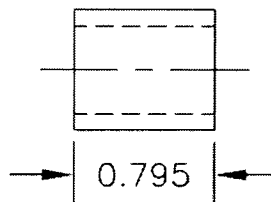
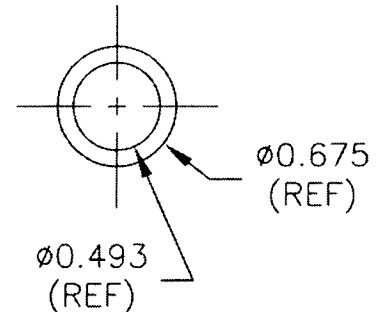
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

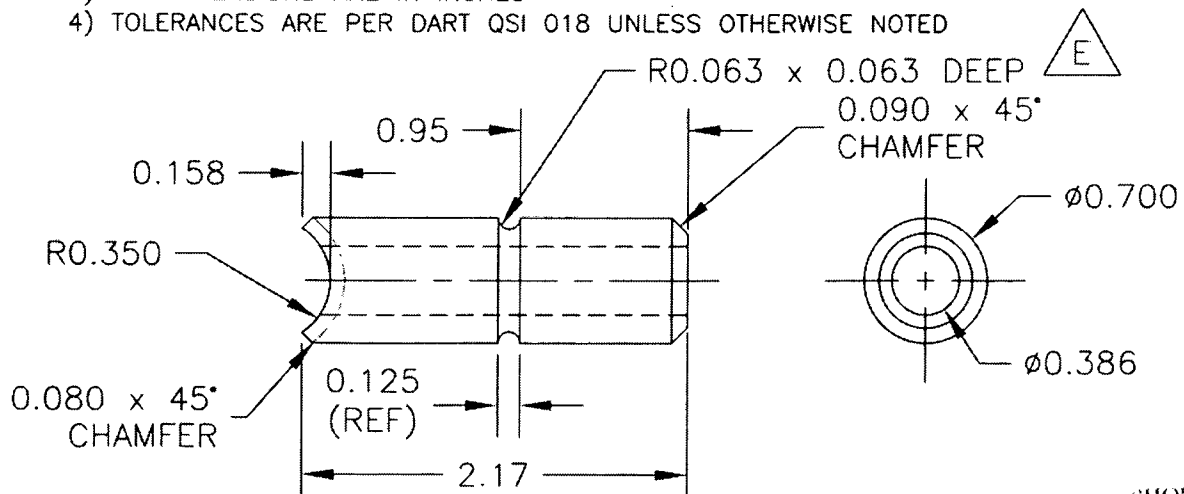
**NOTE:** Date & initial all entries

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              |                                | TITLE<br>HANDLE TUBES   | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE   |                        |
| B                             | 95.03.23                       | RE-DESIGN   |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



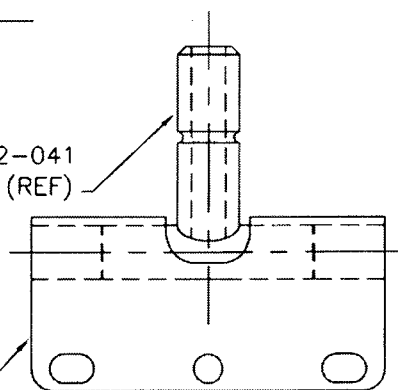
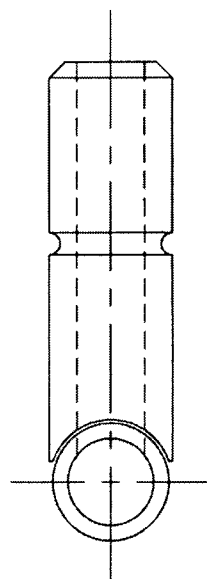
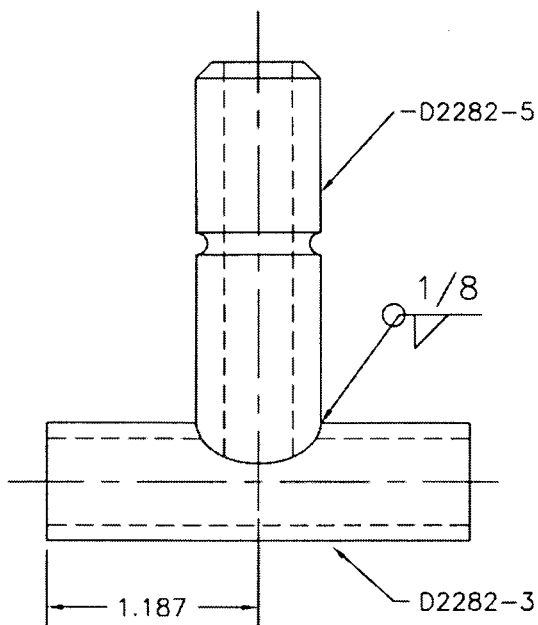
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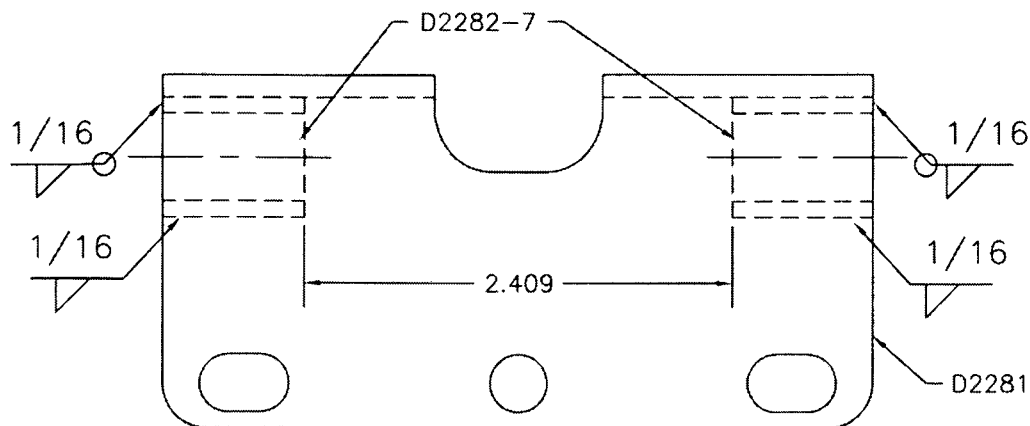


|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |



**D2282-041 'T' ASSEMBLY**  
**WELD ASSEMBLY PER DART QSI 004**

**GENERAL ASSEMBLY**  
**SCALE 1:2**



**D2282-043 SADDLE ASSEMBLY**  
**WELD ASSEMBLY PER DART QSI 004**

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